










Date: Monday, 11/21/2005 12:37:28 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT ASSEMBLY
Job Number : 24884	
Estimate Number : 10808	
P.O. Number : N/A	Part Number : D3180041
This Issue : 11/21/2005 S.O. No. : N/A	Drawing Number : D3180 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>See comment below</u>	Due Date : 12/10/2005 Qty: 5 Um: Each
Checked & Approved By : <u>See comment below</u>	
Comment : Est Rev:A 03.01.27 New issue KJ/RF	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation:
Description :	
1.0	M304TR0750W049 304 RD Tube .750 x .049W
	
	
Comment: Qty.: 3.7625 f(s)/Unit Total : 7.5249 f(s) 304/316 Seamless Tubing with 3/4" O.D. x 0.049" wall (M304TR0.750W0.049) Batch: <u>M18983</u>	
2.0	BRAKE NC. NC BRAKE
	
	
Comment: NC BRAKE	
1-Punch 304/316 Seamless Tubing with 3/4" O.D. x 0.049" wall to length as per Dwg D3180 using DT8313 Ensure rotate and punch one end only as per view B-B as per Dwg. D3180	
3.0	SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1
	
	
Comment: SMALL & MEDIUM FAB RESOURCE 1	
1-Drill Ø0.203" as per Dwg D3180 2-Bend one side only as per Dwg D3180 Identify as D3180-1 3-Deburr edges	
4.0	QC5 INSPECT WORK TO CURRENT STEP
	
	
Comment: INSPECT WORK TO CURRENT STEP	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D3180041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ml 05 12 19 5

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 05/12/2005

7.0

D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2022-101 Spacer B23396

8.0

D26906

Lanyard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2690-6 Lanyard B19300

9.0

A1449

Grommet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3180-1(ref) Strut

1 A1449 Grommet M1487

10.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN960JD10 Washer M16066

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

BLRS001

Pip Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 BLRS-001 Pip Pin M15608

12.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS21042L3 ✓ Nut (or -3) M17652

13.0

MS27039110

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-1-10 Screw M18836

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3180

SB 05/12/20 5

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5-12-20

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 87

605/14/20

(S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

15705/12/20

Job Completion



U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 05/12/20
 QA: N/C Closed: _____ Date: _____

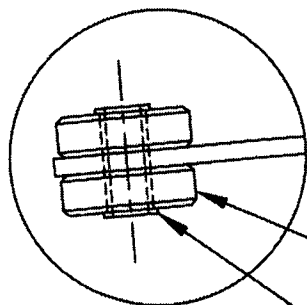
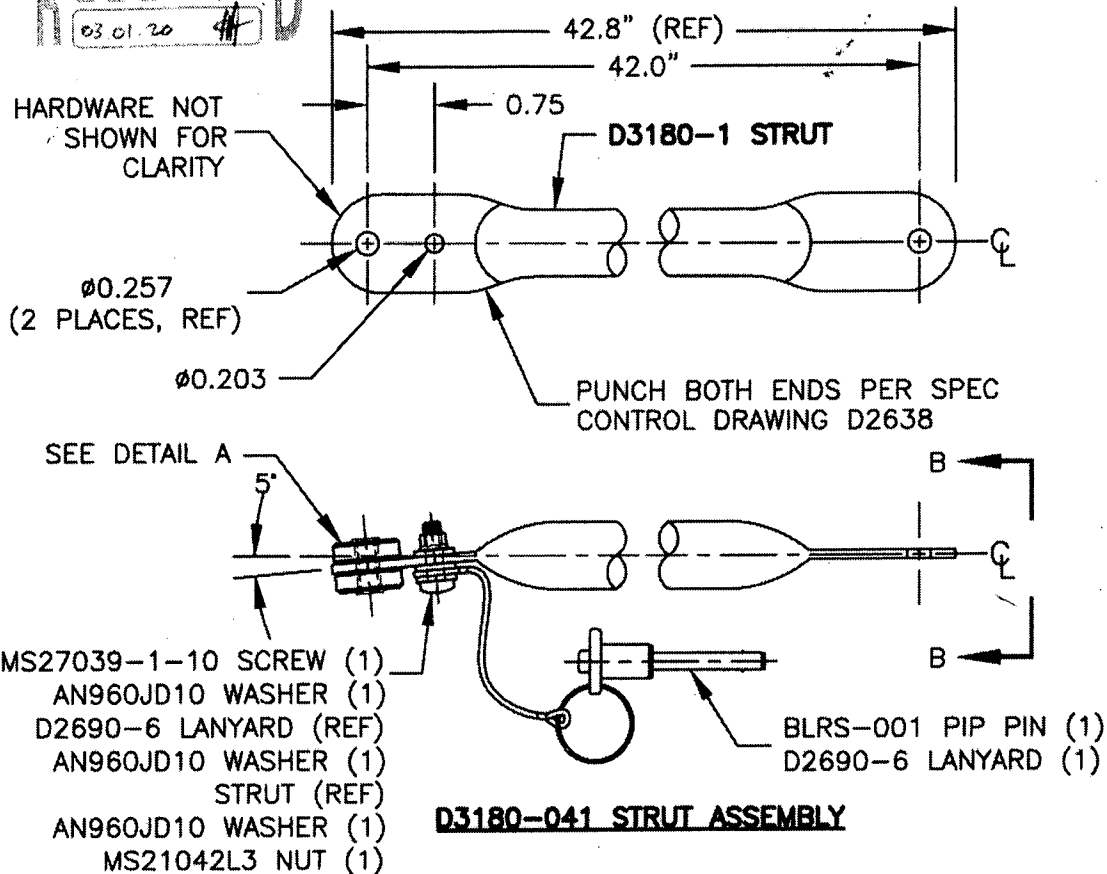
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3180	REV. A SHEET 1 OF 1
DATE 03.01.06	TITLE STRUT ASSEMBLY		SCALE 1:1
A	03.01.06	NEW ISSUE	

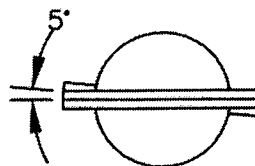
RELEASED
03.01.20



DETAIL A
SCALE 1:1

D2022-101 SPACER
(2 PLACES)

SWAGE D2022-101 SPACERS ONTO
D3180-1 STRUT USING A1449 GROMMET
(1 PLACE)



VIEW B-B
SCALE 1:1

D3180-1 STRUT

- 1) MATERIAL: AISI 304/316/318 SS TUBE, Ø0.75 X 0.049 WALL
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 18, 2005
09:21 am

Work Order No : 0024884
Project Name : D3180-041
Project For : WK549
Work Order Type : Main
Main WO Number :
House Part Number : D3180-041
Description : Strut Assembly
Manufactured : Yes
Amount Req'd : 2
Amount Done : 0
Start Date : 11-18-05
Est Finish Date : 12-10-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00